

del 108

Work Order ID 125776

125776

Page 1

Wednesday, October 22, 2014 12:34:52 PM

Item ID: D3455-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Spacer

Start Date: 10/21/14 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MUS

Date: 14-10-22 Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____ SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3455	Rev A

100 0.00

100 Hardinge CNC LATHE SMALL

Hardinge

Memo 0.00

Hardinge CNC Lathe Small HARDHINGE COBRA1-TURN AS PER FOLIO FA583 & DWG D3455
,FOLIO REV: ✓ DWG REV: ✓ 2-DEBURR AS REQUIRED

16 0 JFC 2014-11-21

110 0.00

110 QC

Memo 0.00

Quality Control

16 0 JFC 2014-11-21

120 0.00

120 QC

Memo 0.00

Quality Control

16 0 JFC 2014-11-21

DAS
40
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
--	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Other				

Work Order ID 125776

Wednesday, October 22, 2014 12:34:52 PM

125776

Page 2

Item ID: D3455-1

Accept

N900040100

Setup

Start

NS1

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12

Cust Item ID:

Required Date: 10/21/14 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

ST 04D

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

DAS
06
9-89

NOV 22 2014

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

14/11/24 20

DAH-11-24

DQA: _____

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved	AGAINST DEPARTMENT/PROCESS <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other
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Doc/Data									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/> Bending			<input type="checkbox"/> Bend			<input type="checkbox"/> Folio/Program			<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric			<input type="checkbox"/> BOM/Route			<input type="checkbox"/> Grain			<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Cracks			<input type="checkbox"/> Broken/Damage/Defect			<input type="checkbox"/> Hardware			<input type="checkbox"/> Set-up
<input type="checkbox"/> Crimp/Kink/Ripple/Wave			<input type="checkbox"/> Burrs			<input type="checkbox"/> Inspection Incomplete/Unqualified			<input type="checkbox"/> Temperature/Cure
<input type="checkbox"/> Cuffs			<input type="checkbox"/> Contamination			<input type="checkbox"/> Instructions Incomplete/Unclear			<input type="checkbox"/> Weld
<input type="checkbox"/> Crushing			<input type="checkbox"/> Countersink			<input type="checkbox"/> Misaligned/off center			<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Heat Treat			<input type="checkbox"/> Cut Too Short			<input type="checkbox"/> Mislabeled			<input type="checkbox"/> Other
<input type="checkbox"/> Inspection Strip in Tube			<input type="checkbox"/> Drawing			<input type="checkbox"/> Misread			
<input type="checkbox"/> Marks/Chatter			<input type="checkbox"/> Drill Holes			<input type="checkbox"/> Off-set			
<input type="checkbox"/> Turning Sequence			<input type="checkbox"/> Finish			<input type="checkbox"/> Out of Calibration			
<input type="checkbox"/> Wave/Twist in Tube			<input type="checkbox"/> Fit/Function			<input type="checkbox"/> Out of Sequence			

Picklist Print

Page 1

Wednesday, October 22, 2014 12:34:52 PM

Work Order ID: 125776

125776
D3455-1

Parent Item: D3455-1

Parent Item Name: Spacer

Start Date: 10/21/14

Start Qty: 12.00

Required Date: 10/21/14

Required Qty: 12.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	61.3100	0.022	1			**

MDFI RINR1 000

Delrin Round Bar 1" color: black

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT039	61.31	
m128667	1.216	
m129774	1.494	
<u>m130065</u>	10.6	
m130187	48	

1 P# JFC 2014-11-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Set-up					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Weld					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Power Loss/Surge						
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<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence							

DART AEROSPACE LTD	Work Order:	125775
Description: Spacer	Part Number:	D3455-1
Inspection Dwg: D3455	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

40

Measured by: Jfc	Audited by: 9-89	Prototype Approval: N/A
Date: 2014-11-21	Date: 14/11/21	Date: N/A

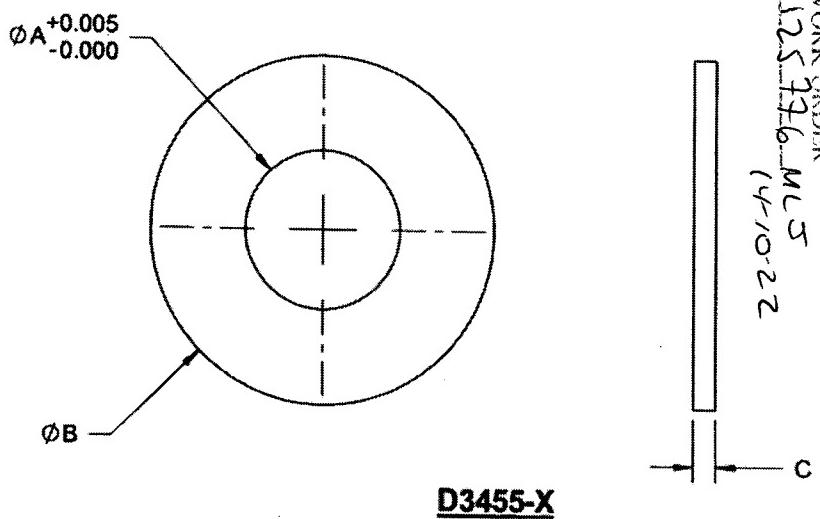
Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM	E



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE 05.09.02		TITLE SPACER	SCALE 2:1
A	05.09.02	NEW ISSUE	

RELEASED

05.12.09 *[initials]*



1) SPECIFICATION: D3455-X SPACER

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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